

Date: Monday, 11/09/2006 10:04:14 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE
 Job Number : 28063
 Estimate Number : 10288
 P.O. Number : N/A Part Number : D25771
 This Issue : 11/09/2006 S.O. No. : N/A Drawing Number : D2577 REV E
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : E
 Previous Run : 28063 Material : N/A
 Due Date : 18/09/2006 Qty: 39 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est: E 02.09.24 Re-format; Incorporated D2577-101/-11 KJ/
 RF
 est F 06.09.11 now waterjet EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S16GA 1010/1025/A21/6aA SHEET



Comment: Qty.: 0.8474 sf(s)/Unit Total : 42.3675 sf(s)
 1010/1025/A21/6aA SHEET M101463 M1 06 09 12

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D2577 (D2577-101 detail)
 Dwg Rev: E
 Prog Rev: E M1 06 09 12 39

2-Deburr if necessary

SAD 0610126 39

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE M1 06 10 12 (39)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK JCB 10.12 (39) Counted

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 1-Form on brake as per Dwg D2577 using DT8155 and DT8179
 2-Form joggle as per Dwg D2577 using DT8157
 3-Identify as D2577-1

SAB 06/11/14 (39)

Date: Monday, 11/09/2006 10:04:14 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 28063

Part Number: D25771

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Deburr if nesasary

N/A

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-11-14

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

CPC06-11-29

Qty Description

Batch

A/R 7560 Hardcoat Rod

M102756 M101217

MF. 06-11-30

(39)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

06/11/30 (39)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

A.M 06/11/30 (39X)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

LB 06/12/01 (39X)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP

A.M 06/12/01

(39X)

12.0

QC21

FINAL INSPECTION/W/O RELEASE.



Comment: FINAL INSPECTION/W/O RELEASE

06/12/01 (39)

Job Completion



u 06-12-01

Date: Tuesday, 8/1/2006 11:29:37 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEARPLATE
Job Number :	28063		
Estimate Number :	10288		
P.O. Number :		Part Number :	D25771
This Issue :	8/1/2006	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2577 REV E
First Issue :	/ /	Project Number :	N/A
Previous Run :	26350	Drawing Revision :	E
		Material :	
Written By :		Due Date :	8/25/2006
Checked & Approved By :	Qty: 50 Um: Each		
Comment :	Est: E 02.09.24 Re-format; Incorporated D2577-101/-11 KJ/ RF		

Additional Product

Water Jet 11/11 08 09 13

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING

**Comment:** PURCHASING

Issue P/O: _____

Email or Ship DXF file to vendor

Laser Cut per Dwg D2577 flat pattern D2577-101

Material release note required

2.0

D25771F

Wearplate Fwd

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

WEAR PLATE FWD

3.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material release note is attached

4.0

QC6

DIMENSIONAL CHECK

**Comment:** DIMENSIONAL CHECK

Inspect dimensions per template D2577-101T

5.0

BRAKE NC

NC BRAKE

**Comment:** NC BRAKE

1-Form on brake as per Dwg D2577 using DT8155 and DT8179

2-Form joggle as per Dwg D2577 using DT8157

3-Identify as D2577-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Tuesday, 8/1/2006 11:29:37 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 28063

Part Number: D25771

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Deburr if nesasary

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

Qty Description

Batch

A/R 7560 Hardcoat Rod

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



RELEASED
00.04.26

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. E
CHECKED	APPROVED	DRAWING NO. D2577	SHEET 1 OF 5
DATE		TITLE	SCALE
00.09.22		WEARSHOE	1:10
A	96.09.16	NEW ISSUE	
B	96.12.04	ADD HARDCOAT WELDS	
C	97.05.30	CHANGE HOLES TO OBOUNDS	
D	98.08.17	CORRECTED DIMENSIONS ON -1 & -3	
E	00.09.22	ADD D2577-101/-11/-13 INCORPORATE DE09176	

7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



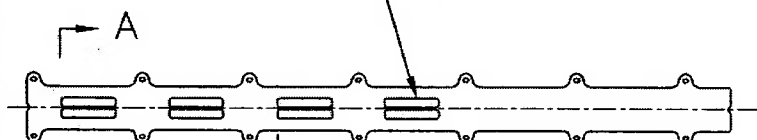
D2577-1 & D2577-3 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

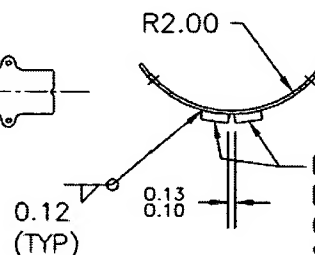
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2941-300
SHWAYDER WEAPADS
(8 PLACES)



SECTION A-A
SCALE 1:5



D2941-300 (REF)
REMOVE POWDER
COAT FROM THESE
SURFACES

1.50 (TYP)

D2577-23 WEARSHOE

MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

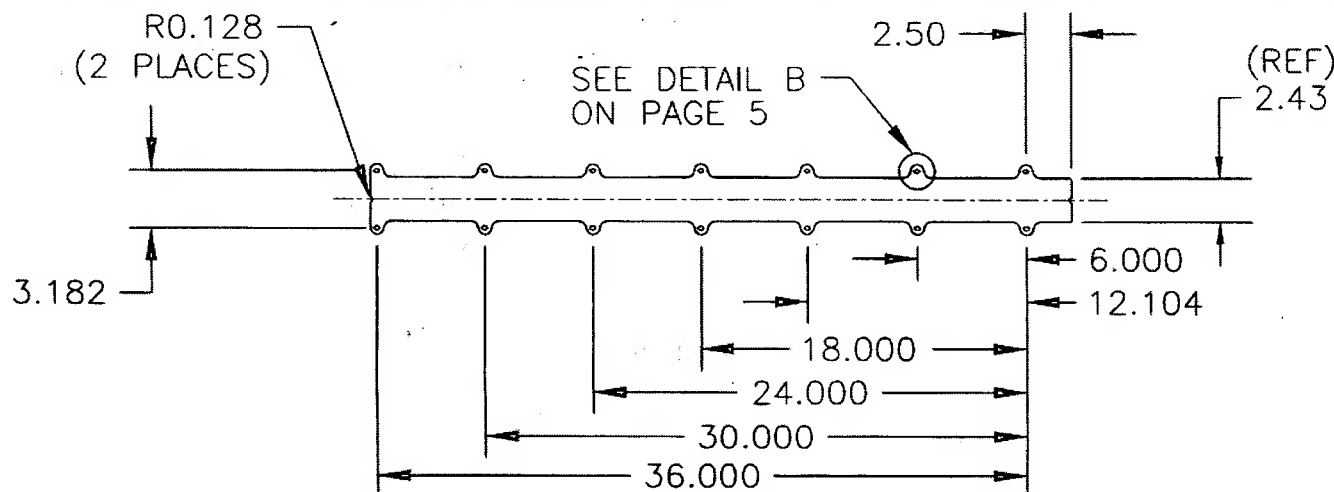
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
SUBJECT TO AMENDMENT
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ENGINEER'S
RETURN TO
SHOP COPY
28063



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CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D2577
DATE	TITLE	REV. E
00.09.22	WEARSHOE	SHEET 2 OF 5
		SCALE 1:10

RELEASED
00.07.26 #7



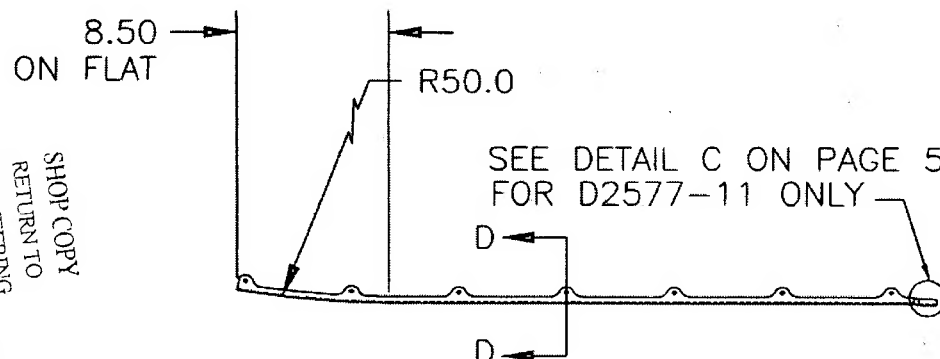
D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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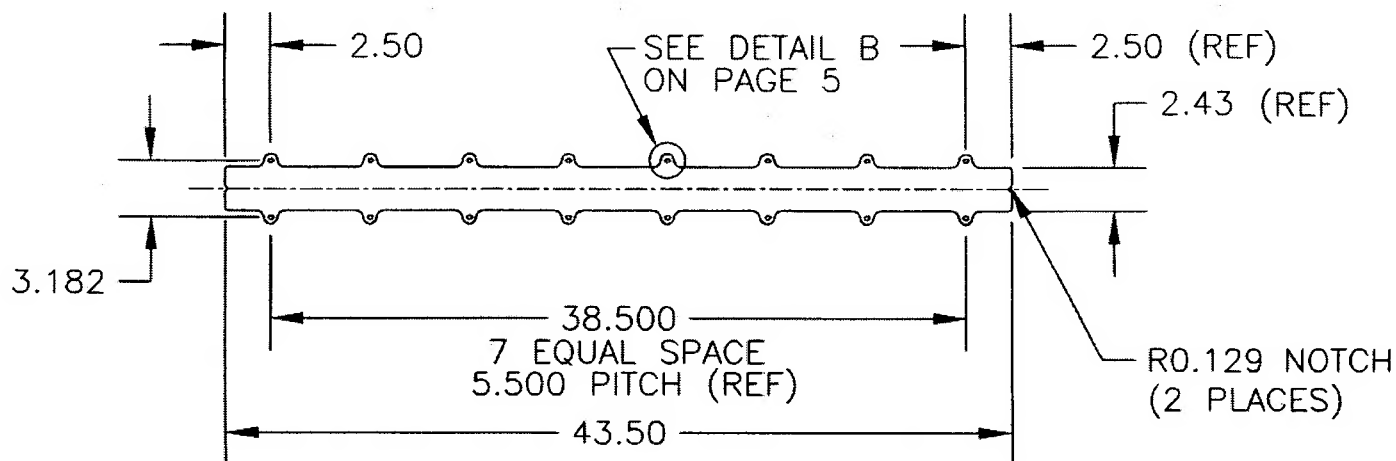
DART



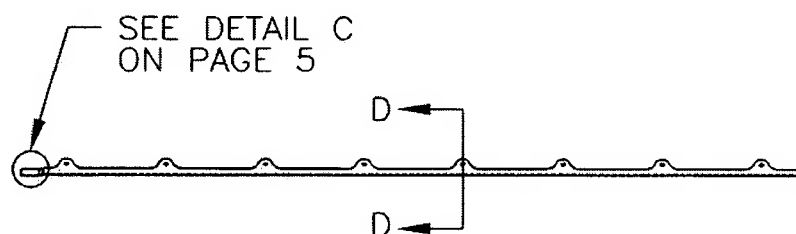
DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	SHEET 3 OF 5
DATE	TITLE	WEARSHOE	SCALE
00.09.22	D2577		1:10

RELEASED
00.09.26

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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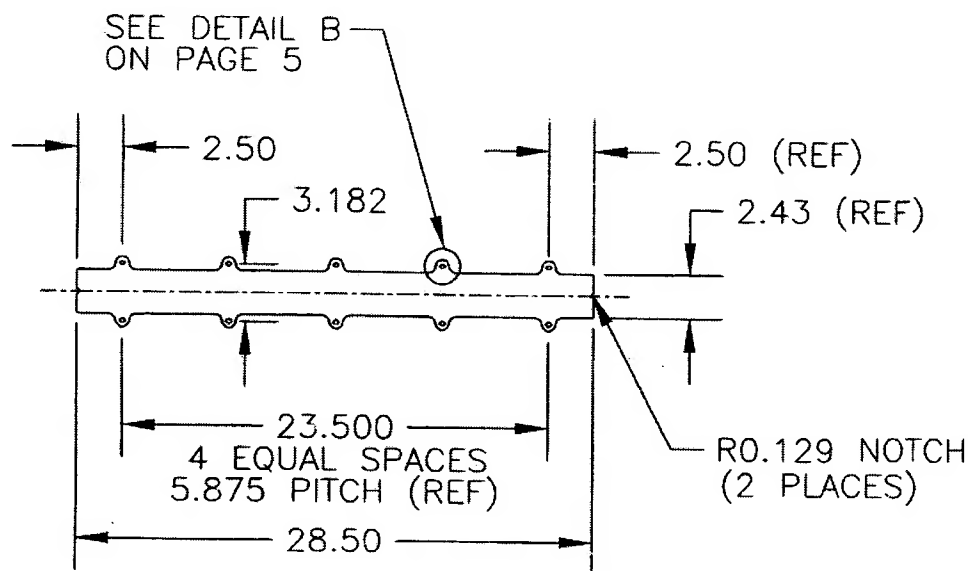
DART



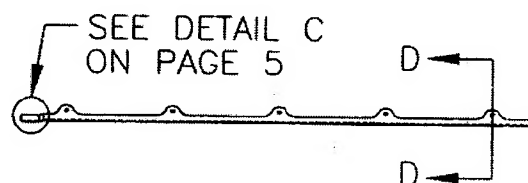
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CHECKED	APPROVED	DRAWING NO.	REV. E		
00.09.22		D2577	SHEET 4 OF 5		
DATE		TITLE	SCALE		
		WEARSHOE	1:10		

RELEASED
00.09.26

D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

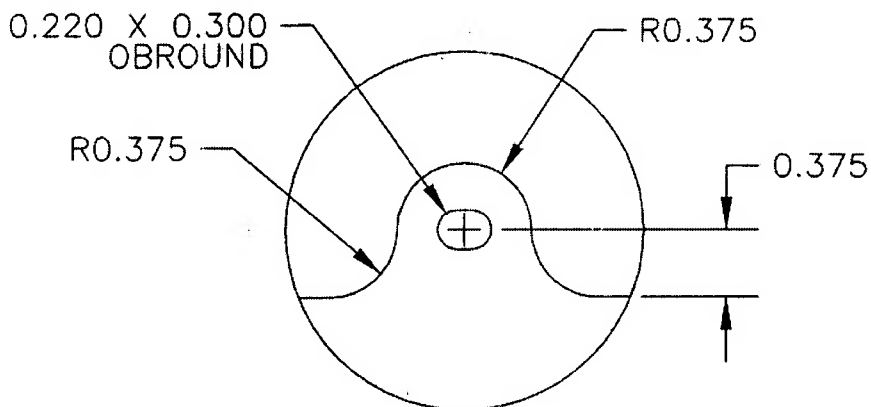
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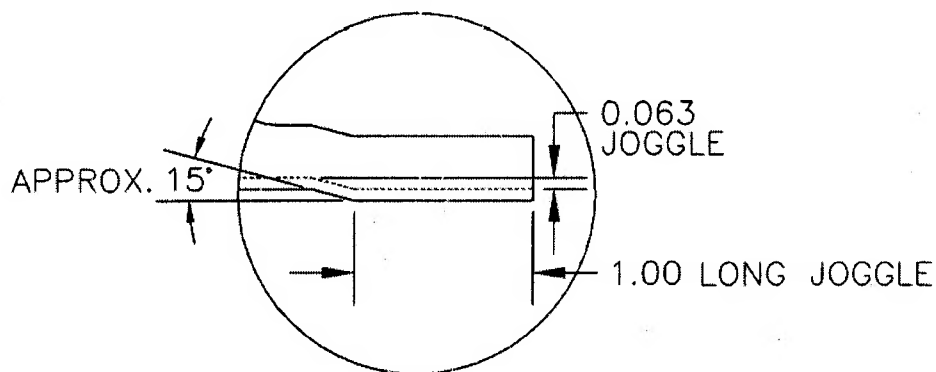
DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2577	REV. E SHEET 5 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

RELEASED
00.09.26

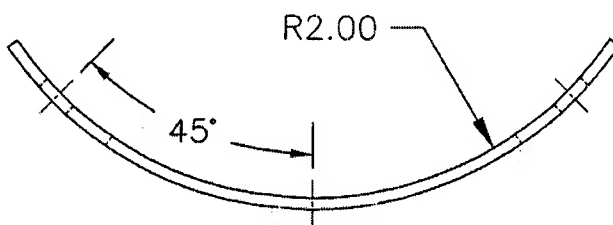
DETAIL B (SCALE 1:1)



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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